

Work Order ID 60559

Wednesday, July 14, 2010 9:17:17 AM



Page 1

Item ID: D3785-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/14/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PS

Date: 10-7-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3785	RevE								
100	FLOW WATER JET	0.00							
	Waterjet								
6061.080									
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3785								
	Dwg Rev: <i>E</i>								
	Prog Rev: <i>E</i>								
	****grain direction 45 degree****								
	2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B 10-8-3

8

B 10-8-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.00 0.00							
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

8/10/08/03

8/10/08/25

8/10/08/25

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-counter sink holes as per dwg D3785

8/10/08/2008

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/08/2008

18

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

=> 11 10/08/2008

18

1

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

MU2588

Memo

0.00

START TIME: 7:35

OVEN TEMPERATURE: 320°

FINISH TIME: 8:05

8 BL 10-8-27

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=> M 10/08/27

8 0

210



Packaging

Packaging

Identify as per dwg & Stock Location: 86

0.00

Memo

0.00

10/8/31 5/8x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 7/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/09/01 *[Signature]*
MF
10-9-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 14, 2010 9:17:21 AM

Page 1
T

Work Order ID: 60559



Parent Item: D3785-3



Parent Item Name: Bracket

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-01 new issue DD verified by:EC
IPP Rev:B 09-01-09 rev.B as per dwg DD verified by:ec
IPP Rev:C 10.04.27 as per dwg revE DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 		Purchased	No			100	sf	75.1234	0.2982	1.255579		2.4 B10-8-3	

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT21

75.12343

113438

2.7512

114351

72.37223

113438

8

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60559
Description: Bracket		Part Number:	D3785-3
Inspection Dwg: D3785	Rev: BE 4/10.08.03	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	X		V/R 62	
6.750	+/-0.010	6.750	X		V	
8.500	+/-0.010	8.503	X		V	
9.927	+/-0.010	9.928	X		V	
0.203	+/-0.010	.203	X		V	
0.405	+/-0.010	.408	X		V	
5.500	+/-0.010	5.500	X		V	
1.500	+/-0.010	1.501	X		V	
3.51	+/-0.030	3.513	X		V	
3.134	+/-0.010	3.137	X		V	
2.259	+/-0.010	2.261	X		V	
1.435	+/-0.010	1.434	X		V	
1.255	+/-0.010	1.254	X		V	
1.427	+/-0.010	1.426	X		V	
Ø0.391	+0.006/-0.001	.391	X		V	
Ø0.201	+0.005/-0.001	.202	X		V	
0.080	+/-0.010	.079	X		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-08-3	Date: 10/08/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	10.02.02	Dimensions revised per Dwg Rev D	KJ	

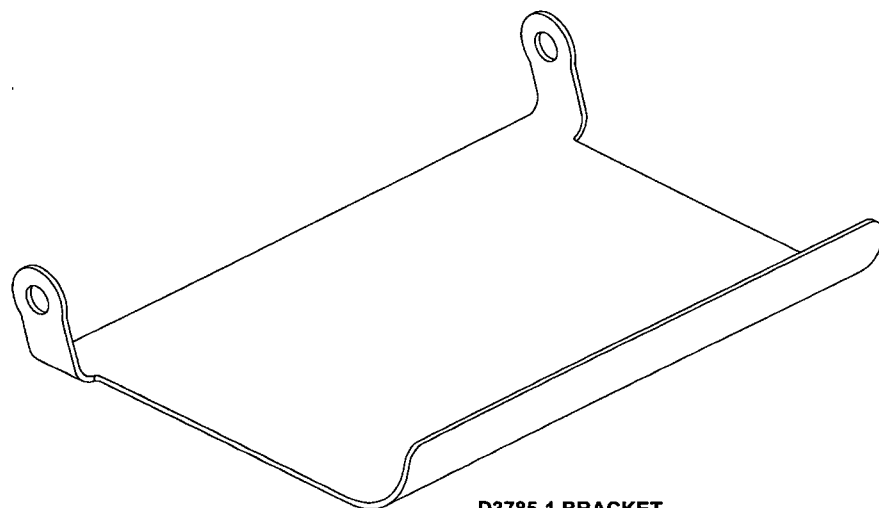
W/O:		WORK ORDER CHANGES					
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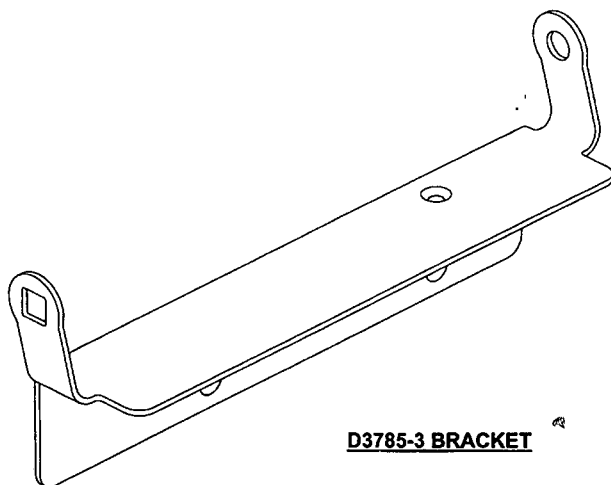
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NOTE: Date & initial all entries



D3785-1 BRACKET



D3785-3 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60559
13810-7-14

RELEASED
2010-04-26
mm

E	ADDED "R0.20 2 PL" DIMENSION (ZN C7-3). REASON: PAR#10-011.	MB	10.04.15
D	REVISED D3785-3 AS FOLLOWS: 1.13 WAS 1.05 (ZN C2-3); 1.500 WAS 2.000 (ZN B7-3); 5.500 WAS 6.750 (ZN B5-3). REASON: PROVIDE MORE CLEARANCE FOR CUSHION UPON ASSEMBLY AND HOLE PATTERN NOT MATCHING D3781-1 HOLE PATTERN.	MB	09.11.26
C	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.07
B	REDESIGNED D3785-3; REMOVED P/Ns D3785-041/-1/-5/-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3785** REV. E
SHEET 1 OF 3
TITLE **BRACKET** SCALE NTS

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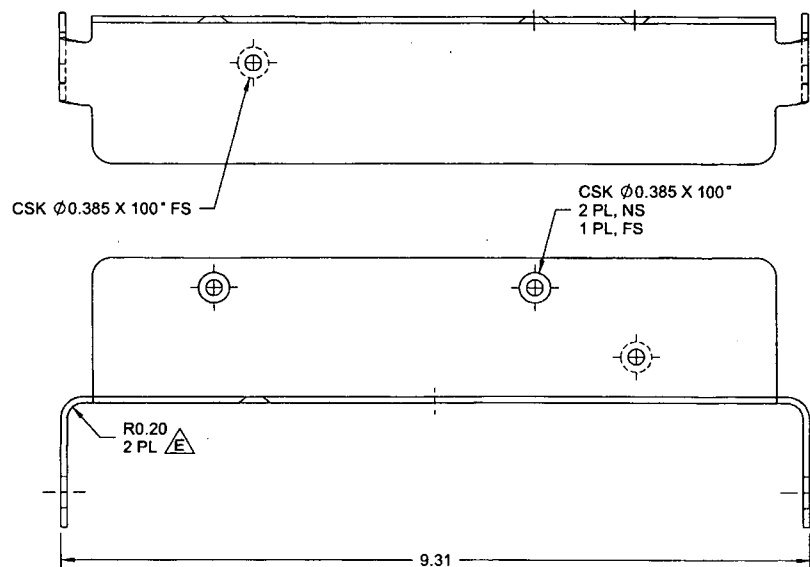
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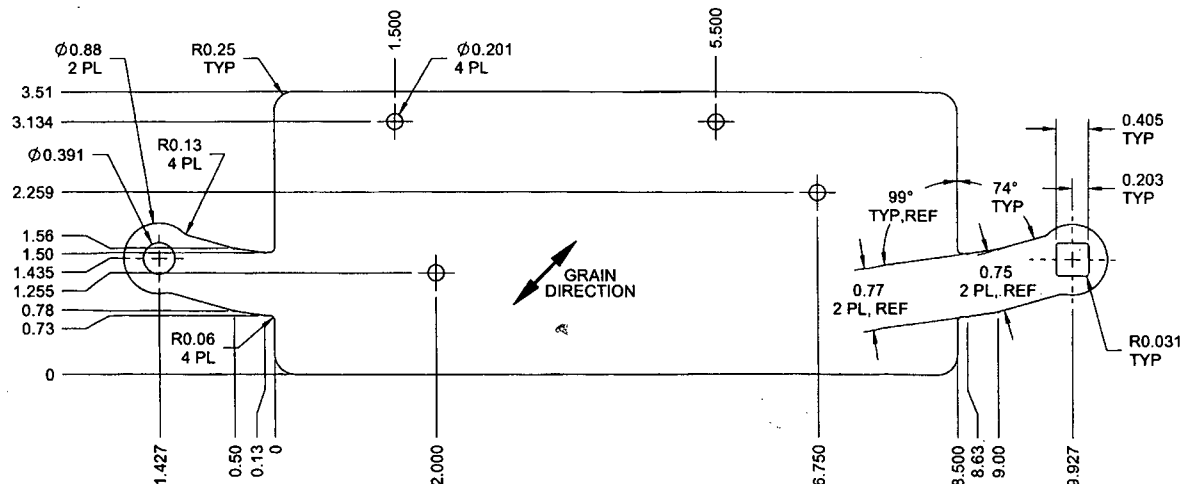
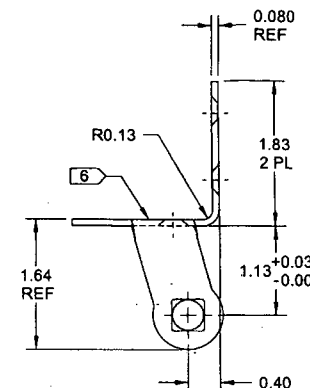
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D3785-3 BRACKET
MAKE FROM D3785-3F








D3785-3F FLAT PATTERN

D3785-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-3" USING FINE
POINT PERMANENT INK MARKER

WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3785	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.04.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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RELEASED
2010-04-26

WLB 60539

W/O:		WORK ORDER CHANGES					
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